

Date: Tuesday, 06/05/2008 7:17:31 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: VERTICAL REFERENCE DOOR 212/412		
Job Number	: 39062			Part Number	: D412711011		
Estimate Number	: 10887			Drawing Number	: N/A		
P.O. Number	:			Project Number	: N/A		
This Issue	: 06/05/2008 S.O. No. :			Drawing Revision	: N/A		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : PURCHASED PARTS			Due Date	: 23/05/2008 Qty: 1 Um: Each		
Previous Run	: 38682			Comment	: Est Rev:A 04.09.29 New issue KJ/JLM		
Written By	:						
Checked & Approved By	:						
Comment							

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
		Comment: DOCUMENT CONTROL Photocopy bluefiles and create labels per PPP D412-711-011 CHG001	 <span style="float: right;">JLD 08.5.06</span>
2.0	PG	PURCHASING	
		Comment: PURCHASING Issue P/O: <u>6304</u> to Eagle Copters "Assembly of D412-711-011 Door Send a copy of this IPP	 <span style="float: right;">C 08/05/06 ①</span>
3.0	D412711041	Vertical Reference Door Assembly	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Vertical Ref. Door Assy	
4.0	D412711101	Replacement Bubble Window	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
5.0	D412711111	Wiring Harness, 212/412	
		Comment: Qty.: 1.0000 Eagle(s)/Unit Total : 1.0000 Eagle(s) Pick: Packing Kit Qty Part Number Description Batch 1 D412-711-111 Wiring Harness, 212/412 _____	

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Seq. #:	Machine Or Operation:	Description :
6.0	EA2046915412	Instrument Panel, 412 
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)		
Pick: Packing Kit		
Qty	Part Number	Description Batch
1	EA20469-15-412	Instrument Panel, 212/412
7.0	OUTSIDE SERVICE	OUTSIDE SERVICES 

Comment: Sub-Contracting OUTSIDE SERVICES

### EAGLE

Pick: Qty Part Number Description Batch

1 204-030-853-119 LH Co-pilot Door \_\_\_\_\_

Attach serviceable tags

### 2- EAGLE

Fabricate/Pick the following parts to go into the door in accordance with:

D2046902 Sheet

1 Rev. 3

D2046902 Sheet 2 Rev. 2

D2046902 Sheet 3 Rev. 0

D2046901 Sheet 3 Rev. 1

Qty	Part Number	Description	Batch
1	EB212-100L / EA20469-3	Window	_____
1	EA20469-05	Rubber Strip	_____
1	EA20469-06	Aluminum Strip	_____
1	EA20469-07	Angle	_____
1	EA20469-08	Placard	_____
1	EA20469-10	Rear Rib Assy	_____
1	EA20469-11	Angle	_____
1	EA20469-12	Fwd Rib	_____
1	EA20469-13	Window	_____
1	EA20469-14	Window Retainer	_____
1	EA20469-16	Armrest Assy	_____
1	EA20469-17	Angle	_____
1	EA20469-18	Door Inner Skin	_____
1	EA20469-21	Door Cover Panel	_____
2	EA20469-23	Link	_____
1	EA20469-24	Rod	_____
1	EA20469-25	Arm Assy	_____

Material Certification / Proof of Traceability / Certificate of Conformity required

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3-EAGLE

Pick:

Qty	Part Number	Description	Batch
14	AN3-3ABolt		
22	AN3-4ABolt		
24	AN3-7ABolt		
6	AN960-6L Washer		
90	AN960-10L Washer		
34	CR3242-4-2 Rivet		
135	MS20426AD3-3 Rivet		
140	MS20426AD4-3 Rivet		
25	MS20470AD3-3 Rivet		
90	MS20470AD4-3 Rivet		
24	MS21042L3 Nut		
2	MS21042L06 Nut		
13	MS21069L3 Nut Plate		
8	MS21069L08 Nut Plate		
1	MS21071L3 Nut Plate		
1	MS21071L08 Nut Plate		
9	MS21075L3 Nut Plate		
2	MS24677-12 Screw		
6	MS27039-1-09 Screw		

4-Assemble door in accordance with : D2046901 Sheet 2 Rev. 5 D2046901 Sheet 1 Rev. 5 Do not install EA20469-15 or wiring harness at this time.

5-Apply Dart P/N & B/N using fine point permanent marker

8.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: Eagle- INSPECT 100% KITS FOR COMPLETENESS

Send this W/O back to DartKit to be stocked at Eagle

9.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

10.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

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11.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

